Work Order ID 105802

August-19-13 11:28:13 AM

105802

Item ID: D3183-044 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Bracket Assembly

Start Date: 8/19/13 **Start Qty:** 8.00 *8*

Required Date: 9/03/13 **Req'd Qty:** 8.00 *8*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MCJ **Date:** 13-08-19 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D3183 / Revision Nbr: Rev C1									
100	BAND SAW	0.00	MH	13/08/28		8	0		
100									
Bandsaw	**Memo**	0.00							
Jeaspa Bandsaw	Cut blanks: (1.500" x 2.250") 5.500" long								
110	HAAS CNC VERTICAL MACHINING #1	0.00	SL/	13-09-12		8	0		
110									
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	1-Machine D3183-4 as per Folio FA322 and Dwg D3183Identify as D3183-42-Deburr3-Scribe batch number								
120	QC2- Inspect parts off machine FAI/FAIB	0.00	SL/	13-09-12		8	0		
120									
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio

☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions

☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other _____

Work Order ID 105802

August-19-13 11:28:13 AM

105802

Item ID: D3183-044 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Bracket Assembly

Start Date: 8/19/13 **Start Qty:** 8.00 *8*

Required Date: 9/03/13 **Req'd Qty:** 8.00 *8*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00				8	0		
130									
QC	**Memo**	0.00							
Quality Control									
140		0.00				8			
140	Small Fab								
Small Fab	**Memo**	0.00							
Small Fab	Assemble D3183-043 as per Dwg D3183.								
150	QC5- Inspect part completeness to step on W/O	0.00				8			
150									
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Work Order ID 105802

August-19-13 11:28:13 AM

105802

Item ID: D3183-044 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Bracket Assembly

Start Date: 8/19/13 **Start Qty:** 8.00 *8*

Required Date: 9/03/13 **Req'd Qty:** 8.00 *8*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: 8T235B	0.00				8			13-9-16
160									
Packaging	**Memo**	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00					13/9/18		
170									
QC	**Memo**	0.00							
Quality Control									

13-0917

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
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- ☐ Cracks
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- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Picklist Print

August-19-13 11:28:16 AM

Work Order ID: 105802 *105802*

Parent Item: D3183-044 *D3183-044*

Parent Item Name: Bracket Assembly

Start Date: 8/19/13 **Required Date:** 9/03/13

Start Qty: 8.00 **Required Qty:** 8.00

Comments: IPP Rev:Pick:A04.02.18New issueKJ/DS
IPP Rev:B Changed Mat Size 08-06-26 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3183-045 *D3183-045* Bearing Assembly		Manufactured	No			100	Each	69.0000	2 **	16			
				Location		**Loc Qty**		**Loc Code**					
				FG		5							
					88587	5							
				ST235B		55							
					103893	16							
					105621	39							
				ST236		9							
					102692	9							
D3121-21 *D3121-21* Bolt		Manufactured	No			140	Each	50.0000	2 **	16			
				Location		**Loc Qty**		**Loc Code**					
				ST235		50							
					102053	1							
					102765	45							
					99292	4							
M174B1.500X02.250 *M174B1.500X02.250* 17-4 SS Bar 1.50 X2.250		Purchased	No			140	f	23.8937	0.4583 **	3.859368			
				Location		**Loc Qty**		**Loc Code**					
				MAT049		23.8937							
					113568	1.9037							
					115806	0.4							
					124158	1.37							
					m126132	20.22							

8/13/09/16

B105953 (16)

8/13/09/16

B105619 (8)

8

3.85 MH 8/08/31

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
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- ☐ Crushed/Crimped
- ☐ Cuffs
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- ☐ Inspection Strip in Tube
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- ☐ Grain
- ☐ Hardware
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- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

DART AEROSPACE LTD	Work Order:	105802
Description: Bracket	Part Number:	D3183-4
Inspection Dwg: D3183 Rev: C1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.190	+/-0.030	.186	✓			
R0.063	+/-0.010	.063	✓			
0.182	+/-0.010	.182	✓		Vern	SL-10
0.070	+/-0.010	.070	✓		?	
0.100	+/-0.010	.107	✓			
Ø0.201 x 0.100	+/-0.010	.199X.098	✓			
0.182	+/-0.010	.182	✓			
5.32	+/-0.030	5.324	✓		H-G	
5.036	+/-0.010	5.033	✓			
2.120	+/-0.010	2.120	✓			
1.290	+/-0.010	1.290	✓		Vern	SL-10
0.365	+/-0.010	.365	✓		?	
0.218	+/-0.010	.214	✓			
1.030	+/-0.010	1.030	✓			
1.90	+/-0.030	1.892	✓			
1.012	+/-0.010	1.010	✓			
Ø0.201 x 0.100	+/-0.010	.199X.099	✓			
0.786	+/-0.010	.787	✓		H-G	
Ø0.392	+0.002/-0.000	.393	✓		mic	SL-4
R0.19	+/-0.030	.188	✓			
3.954	+/-0.010	3.954	✓		H-G	
0.162	+/-0.010	.162	✓			
R0.19	+/-0.030	.188	✓			
R0.25	+/-0.030	.250	✓			
4.26	+/-0.030	4.263	✓		Vern	SL-10
2.800 Calculated dimension	+/-0.030	2.810	✓		V ~	
0.162	+/-0.010	.160	✓		?	
0.615	+/-0.010	.625	✓			
0.435	+/-0.010	.430	✓			
0.200	+/-0.010	.200	✓			
0.381	+/-0.010	.385	✓			
0.032	+/-0.010	.028	✓		D-G	SL-7

Measured by:	SL	Audited by:	[illegible]	Preliminary Approval:	N/A
Date:	13-9-11	Date:	13/09/15	Date:	N/A

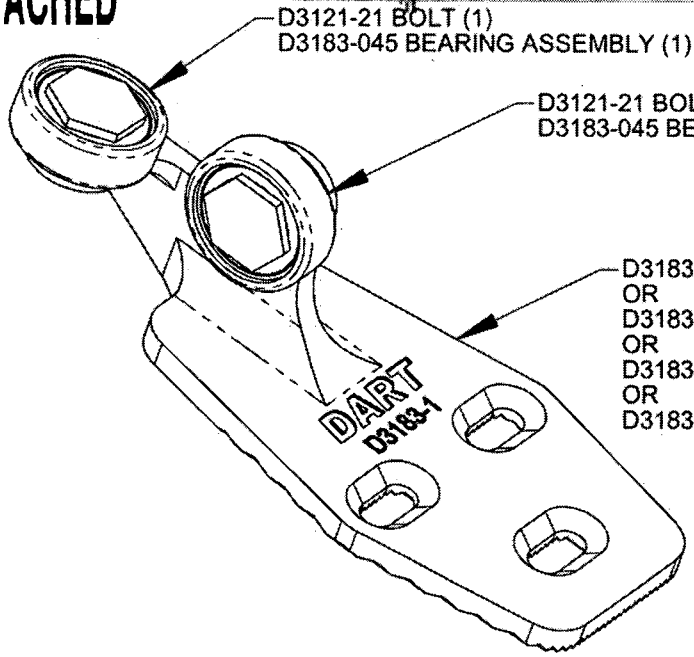
Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D3183-044	KJ/RF	
B	04.03.15	Changes as per revision C	KJ/JLM/RF	
C	04.06.15	Dimension 2.800 was 2.080; removed 1.155, 0.36 dimensions	KJ/JLM	
D	06.03.09	Dwg Rev update	KJ/JLM	
E	08.01.16	Dimensions revised	KJ/EC/DD	
F	10.09.23	Dimensions revised	KJ	KJ AM

DESIGN		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED		APPROVED	DRAWING NO. D3183 REV. C SHEET 1 OF 4
DATE	04.02.17		TITLE BRACKET ASSEMBLY SCALE 1:1

A	03.01.24	NEW ISSUE
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431
C1	04.11.09	0.830 WAS 0.850

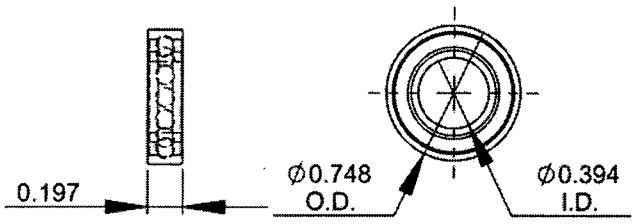
RELEASED 04.03.01

DEO ATTACHED



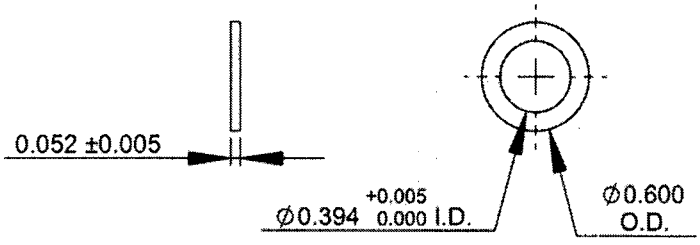
D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)

IS807 MCS 13-08-19



D3183-5 BEARING: SPECIFICATION CONTROL DRAWING

1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
3) ALL DIMENSIONS ARE IN INCHES



D3183-7 WASHER

1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
2) BREAK ALL SHARP EDGES 0.005 TO 0.010
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES

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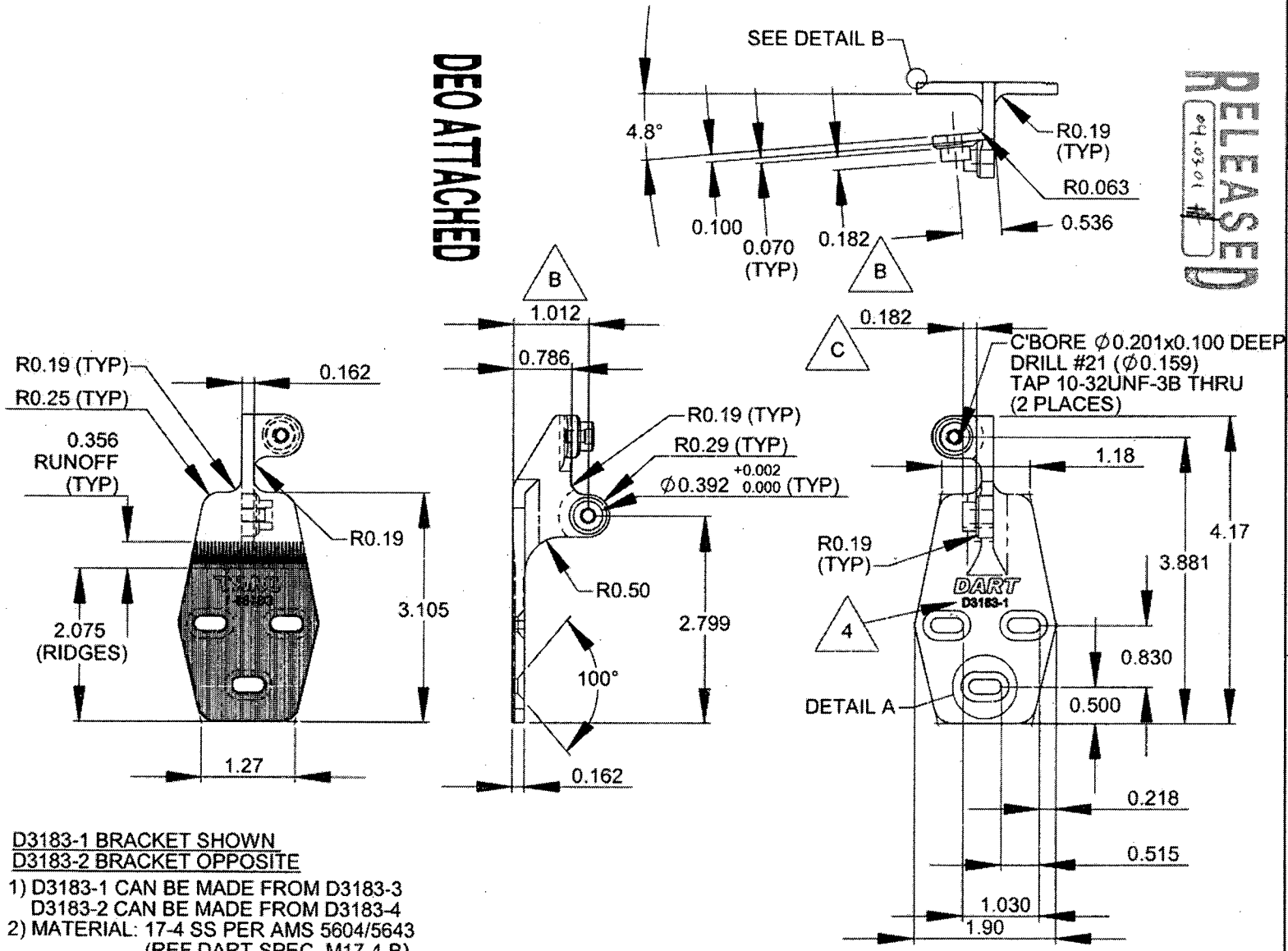
105802

DEO ATTACHED

RELEASED 04.03.01



D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE

1) D3183-1 CAN BE MADE FROM D3183-3
   D3183-2 CAN BE MADE FROM D3183-4
2) MATERIAL: 17-4 SS PER AMS 5604/5643
   (REF DART SPEC. M17-4-B)
   MIN ULTIMATE STRENGTH = 150 ksi
   MIN YIELD STRENGTH = 100 ksi
3) BREAK ALL SHARP EDGES 0.005 TO 0.015
4) ENGRAVE DART P/N & LOGO AS SHOWN
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

DART

DA COPY ISSUED

DESIGN	CHECKED	DRAWN BY	APPROVED
DATE 04.02.17			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3183 REV. C
TITLE BRACKET ASSEMBLY
SHEET 2 OF 4
SCALE 1:2

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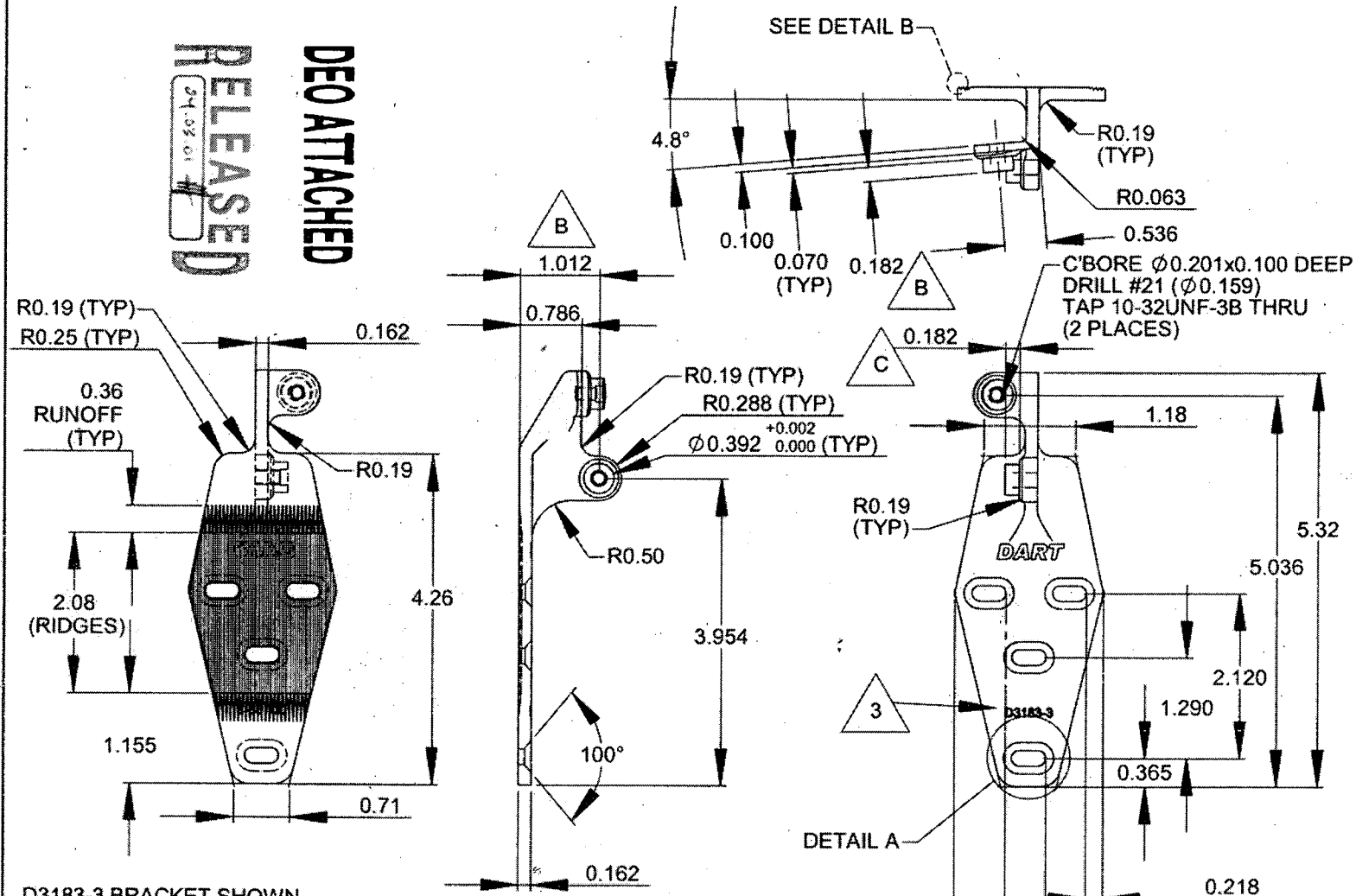
105802

DEO ATTACHED

RELEASED



D3183-3 BRACKET SHOWN
(REPLACES BELL P/N 412-030-304-105)
D3183-4 BRACKET OPPOSITE
(REPLACES BELL P/N 412-030-304-106)

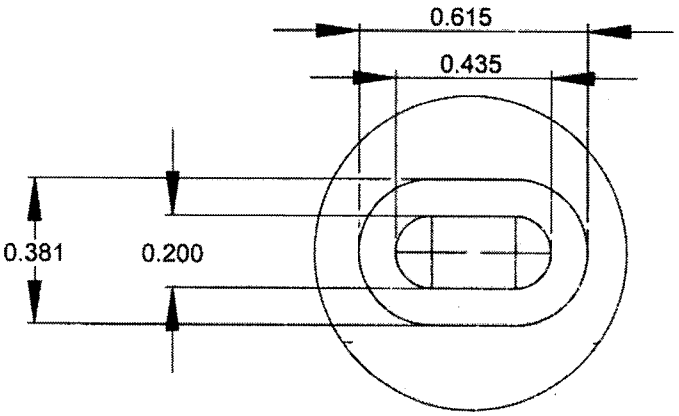
1) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
2) BREAK ALL SHARP EDGES 0.005 TO 0.015
3) ENGRAVE DART P/N & LOGO AS SHOWN
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES

DART

DA COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE 04.02.17	TITLE BRACKET ASSEMBLY	DRAWING NO. D3183 REV. C
		SHEET 3 OF 4 SCALE 1:2

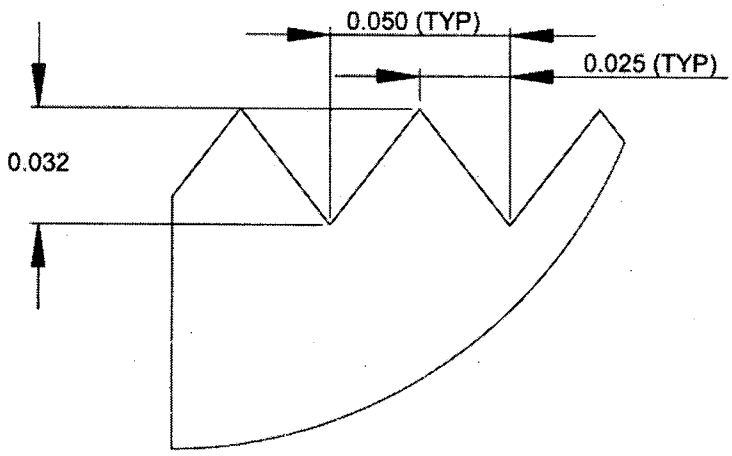
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1



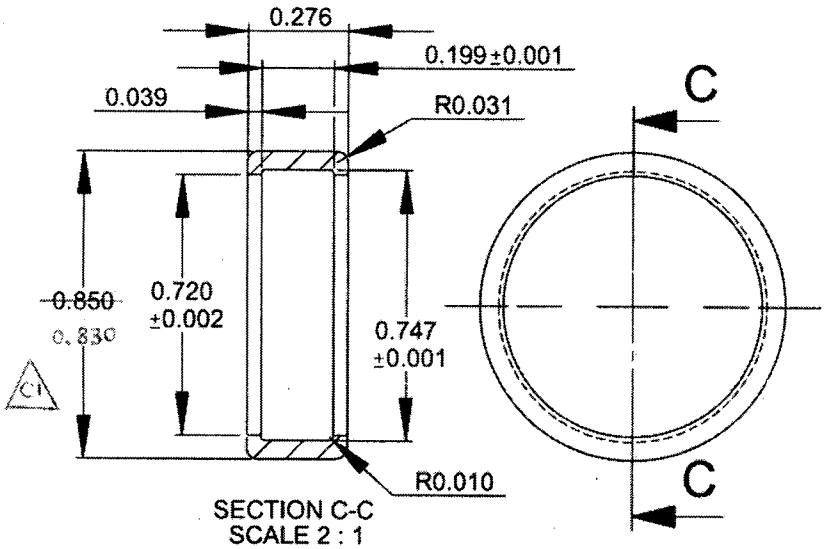
DETAIL A (2 : 1)

RELEASED
04.03.01

DEO ATTACHED



DETAIL B (20 : 1)



SECTION C-C
SCALE 2 : 1

D3183-9 CAP

1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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10802

105802

DRAWING NO.	TITLE	REV.C1	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO.	SHEET NO.	SCALE
D3183	BRACKET ASSEMBLY			D3183-C1-1	SHEET 1 OF 1	NTS

DRAWN	CHECKED	MFG. APPR.	APPROVED	DE APPR.
DATE 10.05.14	DATE 10.06.30	DATE 10.06.30	DATE 10/06/30	DATE 10/06/30

D3183-5 BEARING

ADD POSSIBLE SUPPLIER: KML P/N 6800-ZZ

BASIC LOAD RATING REQUIREMENT: Cr = 1720 N (386 lb) MIN [DYNAMIC]
Cor = 840 N (188 lb) MIN [STATIC]

REF PAR 10-012

RELEASED
2010 -07- 22

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